

Page 1

Item ID:

D3391-023

Accept



Setup Start



Revision ID:

Item Name: Mid Tube Assembly

Start Date: 7/5/2011 Required Date: 7/19/2011 Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

A	pprovals:	
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Process Plan: MF

Date: 11-07-04

Date:

Tooling:

SPC (Y/N):

Date: Date: Run

Stop

Start

Sequence ID/ Work Center ID

Operation **Description** Set Up/ **Run Hours** Tool ID

Tool # Plan

Code

Accept **Qty**

Reject Oty

Reject Insp. Number Stamp

Draw Nbr

Revision Nbr

D3391 Rev H

100

Skidtubes *

0.00

0.00

Skidtubes 3

Skidtubes

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

4-Open saddles and GHW holes to Ø0.375" exept for fwd saddle hole of detail

5-Remove .030" from Fwd indexing Ridge as per Dwg D3391

6-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

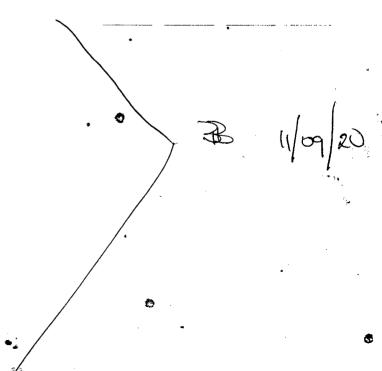
7-Deburr

Memo

8-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

9-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"

10-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391



	WORK ORDER CHANGES							
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	Resolution:		Disposition:	QA: N/C Closed	l:	Date:

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· Work Order ID 71465

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Item ID:

D3391-023

Accept





Revision ID:

Item Name:

Mid Tube Assembly

Start Date:

7/5/2011

Start Qty: 1.00

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Cust Item ID:

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Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date: Run

Stop

Insp.

Sequence ID/ **Work Center ID** Operation Description

Set Up/ **Run Hours** Tool ID

Tool # Plan Code Accept

Reject Qty

Reject Number

Stamp

11-Open .375" holes to .438" ***do not open fwd saddle holes***

12-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

13- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previusly drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previusly tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021

14- Transfer drill 2 wearplate holes into D3391-021 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.

15- Locating from two fwd wearplate holes drilol remaining 6 wearplte holes in D3391-021 using DT8937

16- Open 2 fwd wearplate holes in D3391-023 to .250" dia.

17- counterbore two aft wearplate holes in D3391-021 as per dwg

18- Open 12 wearplate holes in D3391-021 to 0.297" dia.

19-Deburr and blow out all chips from inside tube

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W/O:			WORK ORDER CHANGES					
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Work Order ID 71465

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Item ID: 🐸

D3391-023

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Setup Start

Stop



Revision ID:

Item Name:

Mid Tube Assembly

Start Date:

7/5/2011

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Set Up/

Run Hours

Date:

Run

Start



Required Date: 7/19/2011

Date: SPC (Y/N): Date:

Stop

Sequence ID/ **Work Center ID**

110

Quality Control

Operation **Description**

QC:

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Tool # Plan

Accept Code Qty

Reject Qty

Reject Insp. Number

Stamp

HandFinish Hand Finishing

Memo

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

130

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

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Start Date:

7/5/2011

Start Qty: 1.00

Required Date: 7/19/2011 Req'd Qty: 1.00



Cust Item ID: **Customer:**

Reference:

Process Plan:

Date:

Tooling:

Date: Date: Run

Start

Stop



Sequence ID/

Operation

Description

Skidtubes

Date:

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan

Accept Qty

Reject **Qty**

Reject Insp. Number Stamp

140

Work Center ID

Skidtubes Skidtubes

Memo

0.00

0.00

1-Open float bag holes as per dwg 2-C'sink float bag holes as per dwg

3- Prepare tube for welding

4-Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)
A/R Sikaflex exp: 12-4-5

batch#: ~118 39 3

QC5- Inspect part completeness to step on W/O

Code

150

0.00



Quality Control

Memo

0.00

(@ Ber/10/26

160

Skidtubes

Skidtubes

0.00

Memo

0.00

Skidtubes

1-Weld crossbolt spacer as per dwg D3391 & QSI 004

2-grind weld flush

Dail Ac	ospace	Ltu							
W/O:			WC	RK ORDER CHANG	ES				<u>, , , , , , , , , , , , , , , , , , , </u>
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Item ID:

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Mid Tube Assembly

Start Date:

7/5/2011

Start Oty: 1.00

Required Date: 7/19/2011

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/ Work Center ID

170

Quality Control

Operation Description

QC10- Inspect visual per QSI004- ground welds

Memo

Memo

Set Up/ Run Hours

Tool ID

Code

Tool # Plan

Accept Qty

Reject Otv

Reject Insp. Number Stamp

180

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

185

HandFinish Hand Finishing

0.00

0.00

Memo AND REALODINE AS PER PAR09-043

Pressure Wash per QSI005 4.3

XDML 11/10/27

W/O:		WORK ORDER CHANGES										
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Page 6

Item ID:

D3391-023

Accept



Setup Start

Stop



Revision ID:

Item Name:

Mid Tube Assembly

Start Date:

7/5/2011

Start Qty: 1.00

Required Date: 7/19/2011

Req'd Qty: 1.00



Date:

Cust Item ID: Customer:

Reference:

At	pro	ova	ls:

Process Plan:

Date:

0.00

Tooling: SPC (Y/N): Date:

Date:

Run

Start



Stop

Sequence ID/ Work Center ID

Operation Description Set Up/ Run Hours

Tool ID

Tool # Plan Code

Accept Qty

Reject **Qty**

Insp. Reject Number Stamp

190

Powdercoat

Powder Coating

START TIME: OVEN TEMPERATURE:

FINISH TIME:

White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum

QC3- Inspect Part Finish

Memo

0.00

0.00

Quality Control

W/O:			N	ORK ORDER CHANG	GES		*			10
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Work Order ID 71465

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Item ID:

D3391-023

Accept

Setup Start

Revision ID: Item Name:

Mid Tube Assembly

Start Date:

Required Date: 7/19/2011

7/5/2011

Start Oty: 1.00

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

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	D. O. Hills.

Process Plan:

Date:

Tooling:

SPC (Y/N):

0.00

0.00

Date:

Date:

Run

Start

Stop



Stop

Sequence ID/ Work Center ID

Operation Description

Skidtubes

Set Up/ **Run Hours** Tool ID

Tool # Plan Code Accept Oty

Reject Oty

Reject Number

Insp. Stamp

210

Skidtubes

Skidtubes

Date:

1- insert D3391-021 into D3391-23

insert T-pins into first and third fwd saddle holes

3- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per DSI 9364

A- remove T-pins and locate DT9415 from first and third crossbolt hole using Tpins and clekos

5- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". Remove DT9415

6- deburr, re-alodine and blow out chips

7- press fit D3591-1 spacers using DT9416 starting from 0.500" side

220

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

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W/O:			W	ORK ORDER CHANG	iES			ą
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Item ID:

D3391-023

Accept



Setup Start



Revision ID:

Item Name:

Mid Tube Assembly

Start Date:

7/5/2011

Start Oty: 1.00

Required Date: 7/19/2011

Req'd Qty: 1.00



Cust Item ID:

Customer:

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Stop

Sequence ID/ Work Center ID

230

HandFinish

Hand Finishing

Operation Description

HandFinishing

Memo

Memo

Install Inserts as per Dwg

Set Up/ **Run Hours**

0.00

0.00 , .

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

240

250

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

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Identify as per dwg & Stock Location: W O

0.00 D412-742-043/B7556Z

Memo

0.00

Packaging

Packaging

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W/O:			W	ORK ORDER CHANG	ES				,
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Item ID:

D3391-023

Mid Tube Assembly

Item Name: **Start Date:**

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7/5/2011

Start Oty: 1.00

Required Date: 7/19/2011

Req'd Qty: 1.00



Accept



Setup Start

Stop



Cust Item ID:

Customer:

Reference:

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Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start



Stop



Sequence ID/

Work Center ID

260

Quality Control

Operation Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/ Run Hours

0.00

0.00

Tool ID

Tool # Plan Code Accept Qty

Reject Oty

Reject Insp. Number Stamp

W/O:			WC	RK ORDER CHANG	ES					
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Picklist Print

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Work Order ID: 71465

Parent Item:

D3391-023

Parent Item Name: Mid Tube Assembly

Start Date: 7/5/2011 Start Qty: 1.00

Required Date: 7/19/2011

Page 1

Required Qty: 1.00

Comments:

IPP A□05.10.20□New Issue□

IPP B□06.02.10□ECN773 dwg rev.D

IPP C 07.03.20 rev F dwg

IPP D 07.03.28

re-format IPP E 07.10.31 ecn 1053P

IPP Rev:F ECN 1056 07-11-13 DD verified by: EC

IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC

IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

KJ/EC□

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Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route. Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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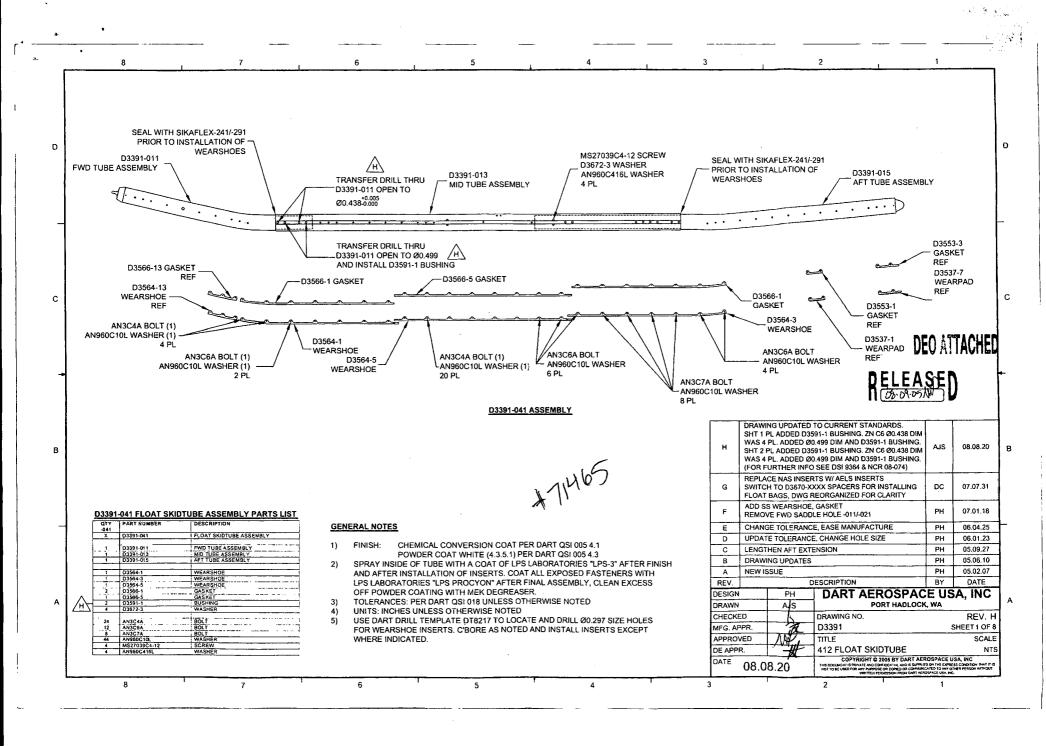
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DATE	STEP	Description of NC			ction B		Verific	ation		Approval	Approval
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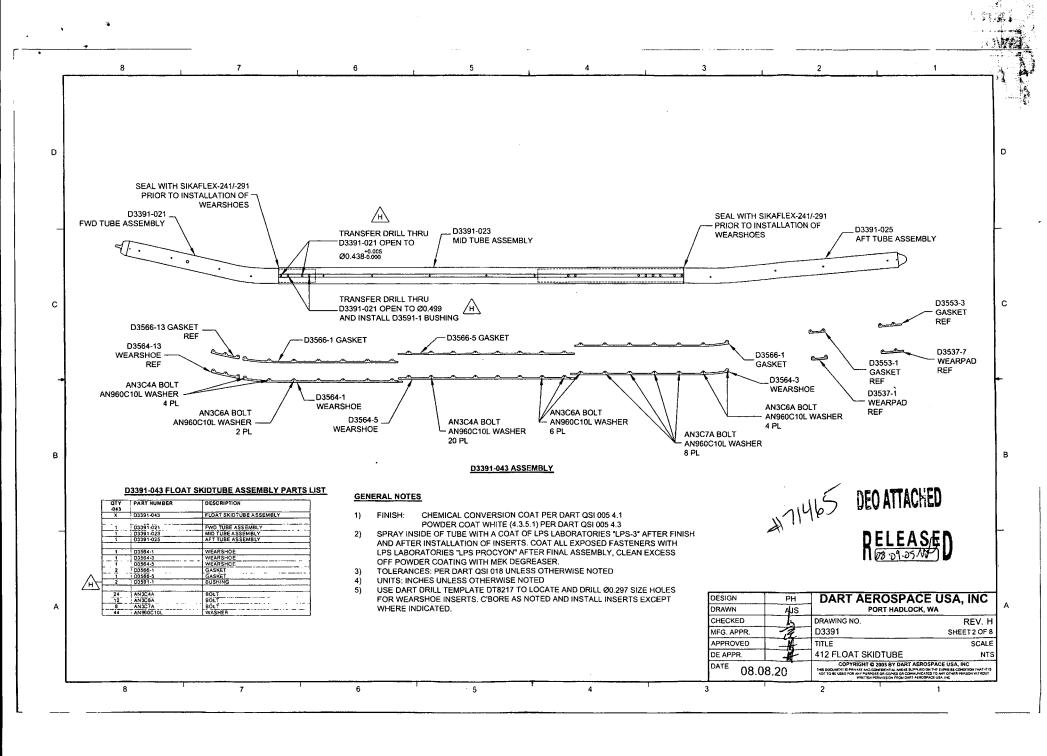
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Work Order ID: 71465 Parent Item: D3391-023 Parent Item Name: Mid Tube Assembly Required Date: 7/19/2011 Start Date: 7/5/2011 Start Qty: 1.00 Required Qty: 1.00 D3681-1 Manufactured No 160 9.0000 Each 5 Spacer Location Loc Qty Loc Code LG 68958 2 69893 7 D3591-1 Manufactured No 210 Each 27.0000 Bushing Location Loc Qty Loc Code ST068 27 57350 2 66147 25 ALS4-1032-130 Purchased No 230 Each 1,002.000 20 ALST-1032-136 Location Loc Qty Loc Code ST281 M 118966 V20 117331 ST282 . - . 994 117717 994

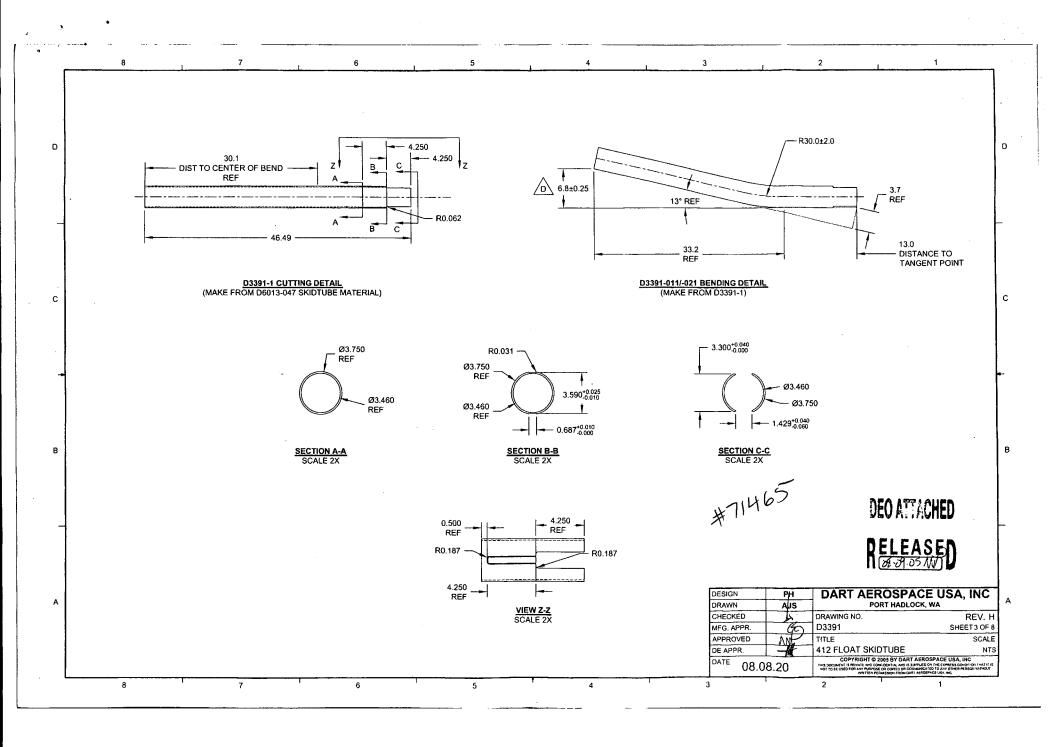
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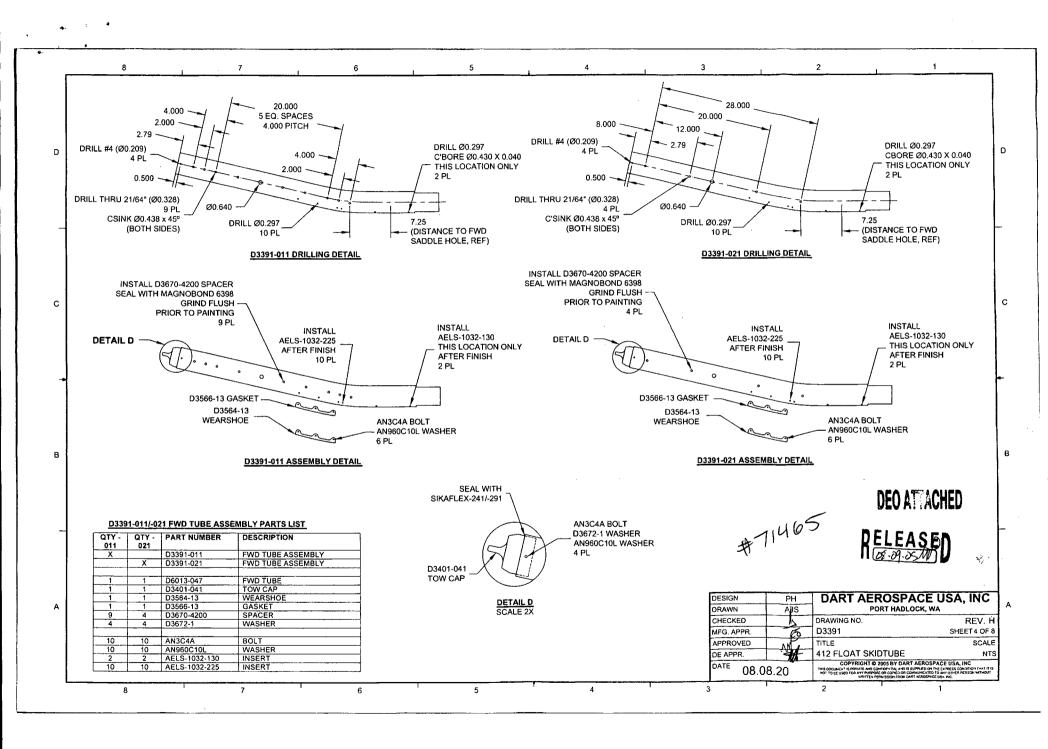
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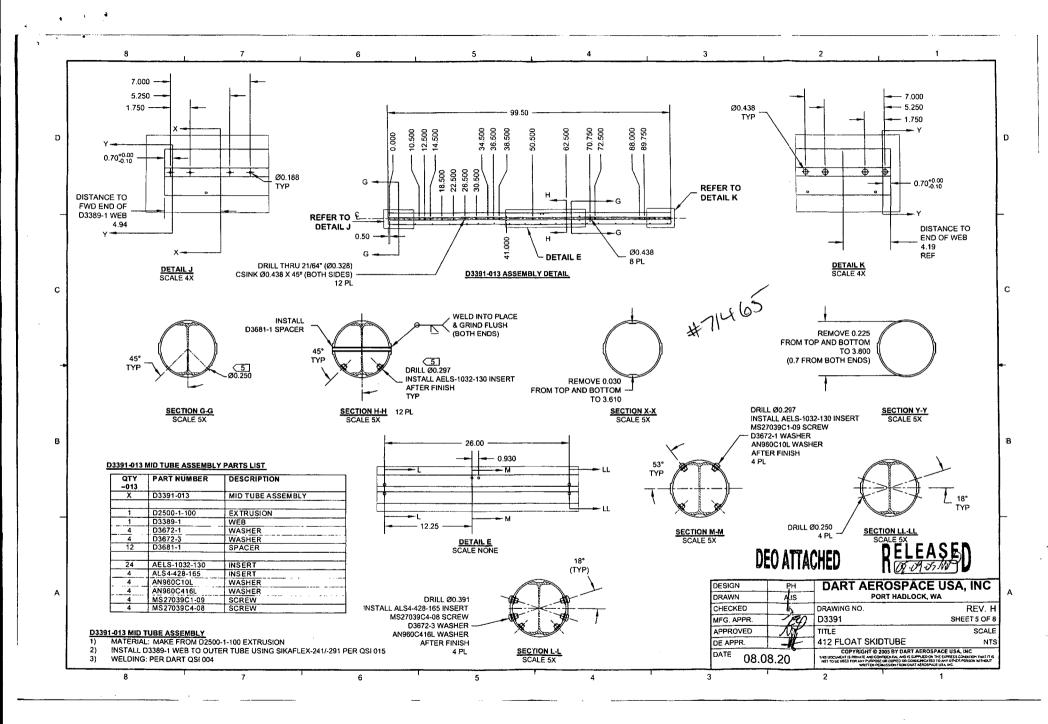


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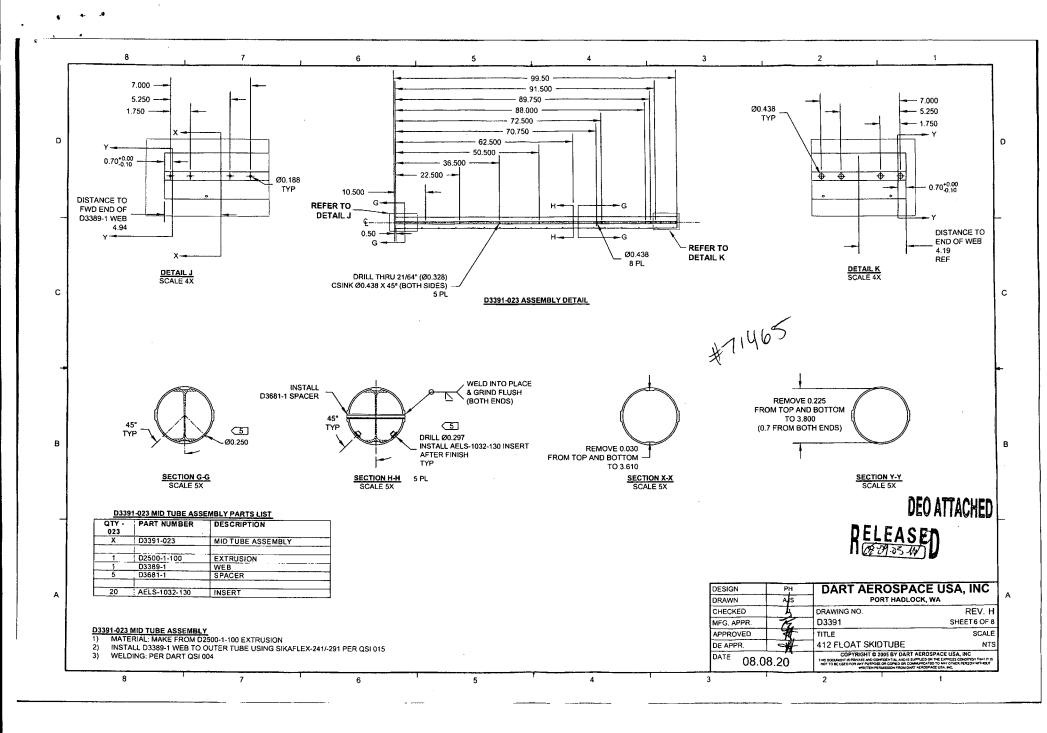


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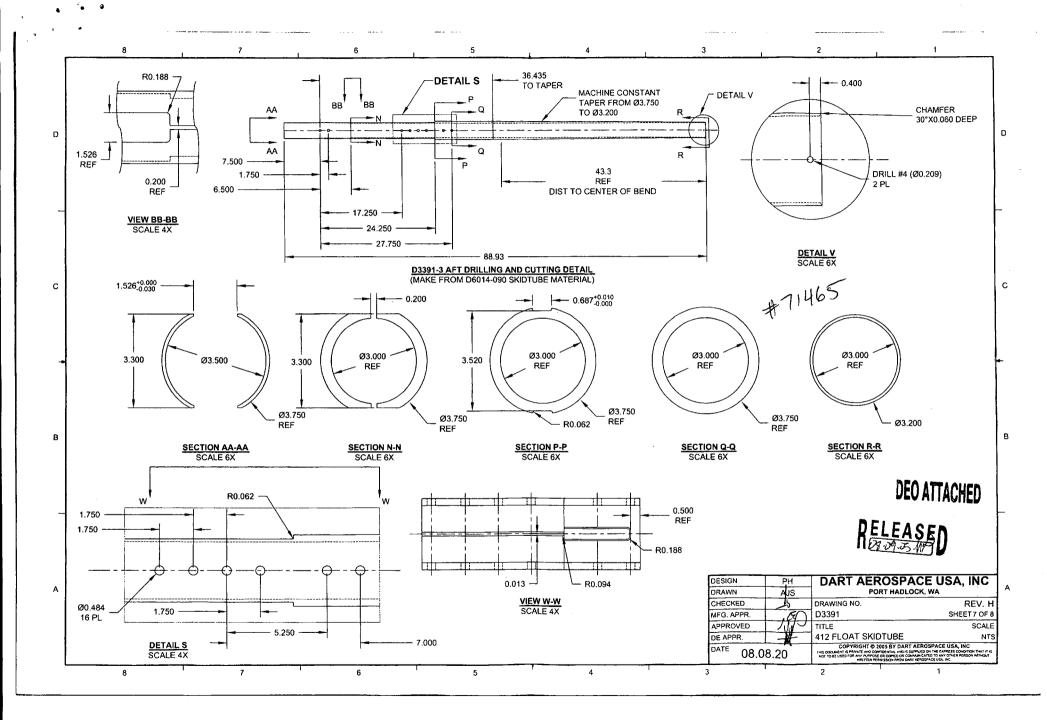


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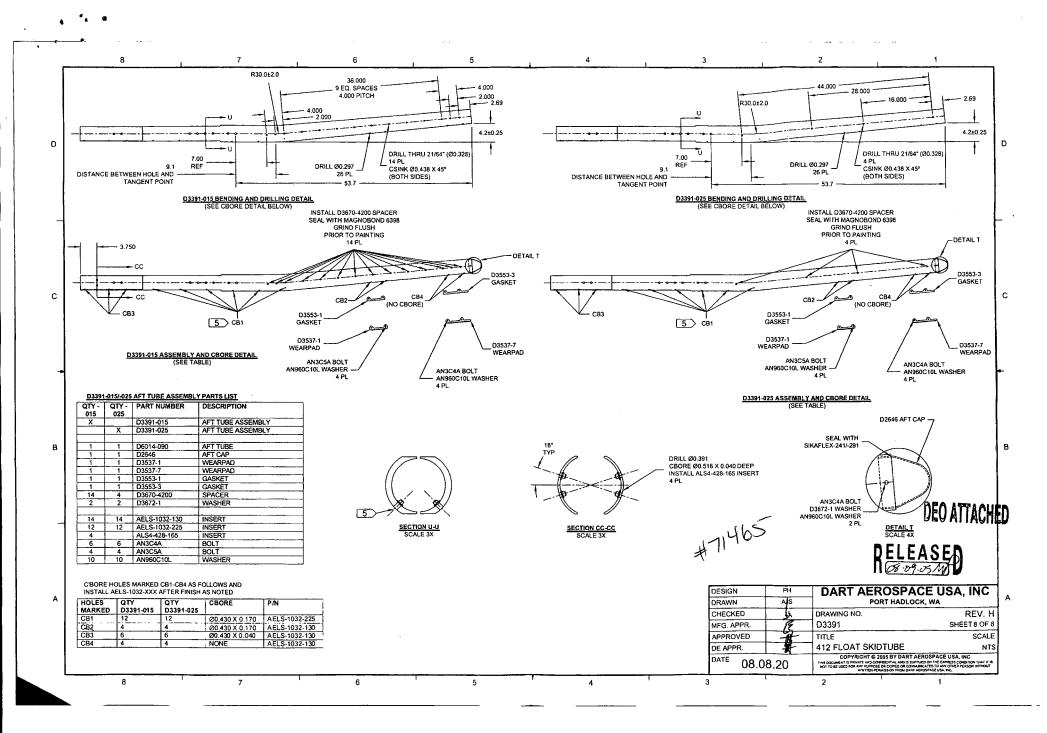
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DRAWING	NO. TI	ITLE		REV. H	DART AEROSPA	CE USA, INC D.E.C), NO.	SHEET NO).	SCALE
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PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

DELEASED 2010 -02- 0 2

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Mike Petsche

From:

Linda Lacelle < llacelle@dartaero.com>

Sent:

Thursday, October 27, 2011 5:06 PM

To: Subject: 'Mike Petsche'; dshepherd@dartaero.com FW: NEW PO 12248 FOR BRISTOW US LLC - CP/SH

fyi

From: Shirley Hay [mailto:SHay@darths.com]

Sent: October-27-11 3:55 PM

To: Linda Lacelle; Nancy MacLeod; sbedford@dartaero.com; mfauteux@dartaero.com; 'Brigitte Golden';

rmolnar@dartaero.com

Cc: Linda Pilon; Carole O'Rourke; Carrie Pearson

Subject: RE: NEW PO 12248 FOR BRISTOW US LLC - CP/SH

Hello

Please send out the old configuration

Regards

Shirley Hay

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, October 26, 2011 3:34 PM

To: Nancy MacLeod; sbedford@dartaero.com; mfauteux@dartaero.com; <a href="mailto:bright: brighted by-bright: bright: brighted by-bright: bright:
Cc: Linda Pilon; Shirley Hay; Carole O'Rourke; Carrie Pearson Subject: RE: NEW PO 12248 FOR BRISTOW US LLC - CP/SH

There has been a recent engineering change on the float skids, and the earliest we can ship these would be the week Nov. 7th, or we ship the current CHG number with the old configuration of wearplates...please let mw know how you would like to proceed.

Linda

From: Nancy MacLeod [mailto:NMacLeod@darths.com]

Sent: October-20-11 1:56 PM

To: 'sbedford@dartaero.com'; 'llacelle@dartaero.com'; 'mfauteux@dartaero.com'; Brigitte Golden; rmolnar@dartaero.com

Cc: Linda Pilon; Shirley Hay; Carole O'Rourke; Carrie Pearson Subject: NEW PO 12248 FOR BRISTOW US LLC - CP/SH

Please see the attached PO for Bristow US LLC.

If you require any further information, please let me know. Thank you,

NO. 264

AWS D17.1.2001 QUALIFICATION TEST RECORD

Current: AC[X] DC[]	Strequirements and R	RESULTS
Visual: Penetration:	pass[V fail[] pass[Y fail[]	
UNACCEPTABLE		
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[V] fail[] pass[V] fail[] pass[V] fail[] pass[V] fail[] pass[V] fail[] pass[V] fail[]	
Qualifier fort fort	Date of Test Coupon // C	

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

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